

Tuesday, 29/04/2008 11:31:04 AM
Melanie Fauteux

Process Sheet

OK

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : BACK LEG
 Job Number : 38888
 Estimate Number : 10804
 P.O. Number :
 This Issue : 29/04/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : R & D SM/MED FAB
 Previous Run : 38880
 Part Number : D37721
 Drawing Number : PROTOTYPE
 Project Number :
 Drawing Revision : A 08.04.23
 Material :
 Due Date : 16/05/2008 Qty: 4 Umi: Each
 Written By :
 Checked & Approved By :
 Comment :

Additional Product

PROTOTYPE

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

MAKE PER DRWG D3772 REV A

22.36 L.

FF 08-05-30

(4)

2.0

M304TR1250W125

304 RD Tube 1.250 x .125w



Comment: Qty.: 2.3000 f(s)/Unit Total: 9.2000 f(s)

M107952

FF 08-05-30

(4)

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

FF 08-05-30

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

GIVE TO CHRIS P-ENG

FOR ENGINEERING USE ONLY -

CHARGE TO JOB #00196

FF 08-05-30

5.0

QC21

FINAL INSPECTION/W/O RELEASE



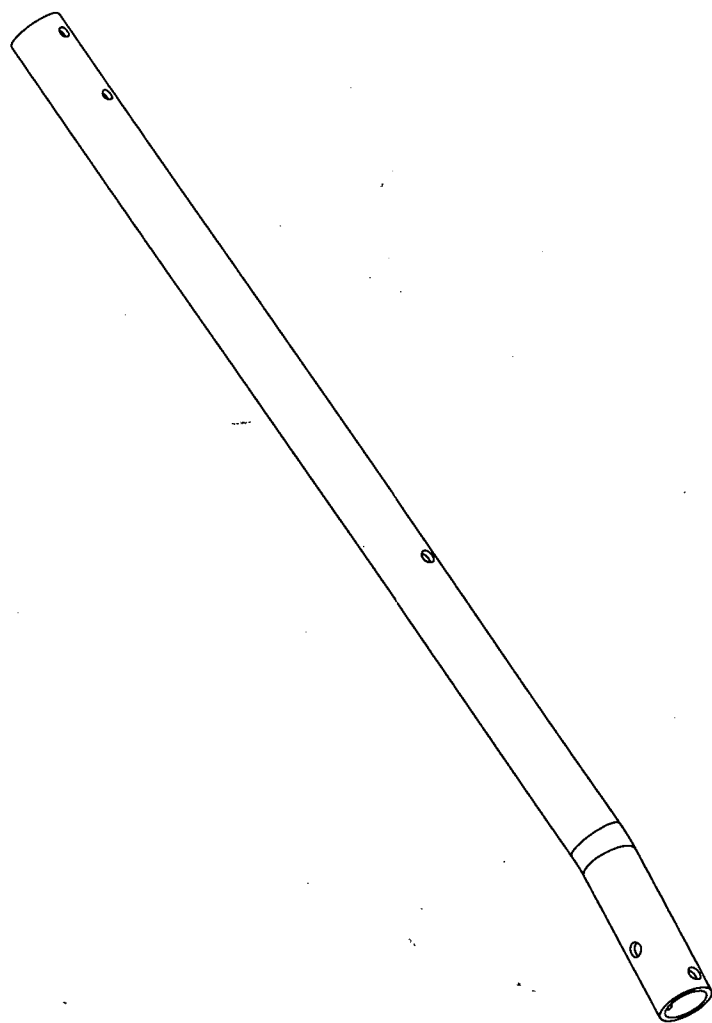
Comment: FINAL INSPECTION/W/O RELEASE

FF 08-05-02

Job Completion



W 08-06-11



D3772-1 BACK LEG

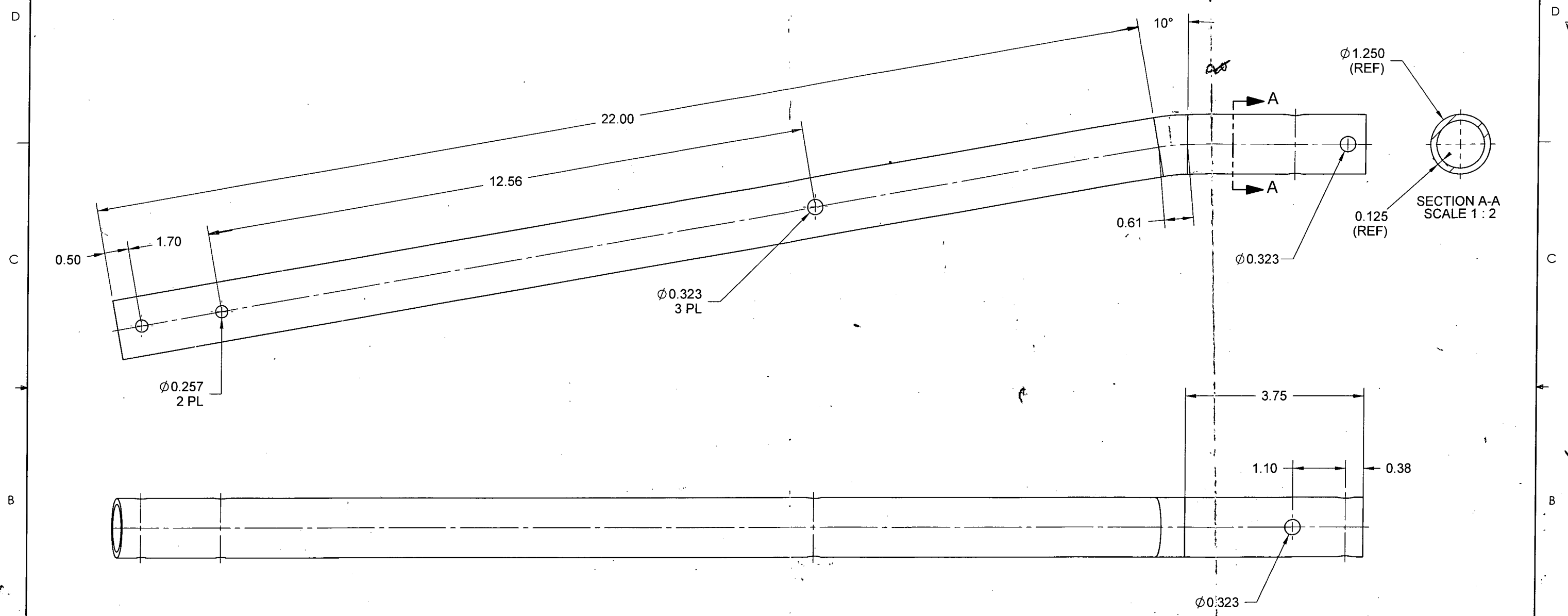
PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

UP 08.04.23

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS TUBING 1.25" OD X 0.125" WALL (REF DART SPEC M304TR1.25W.125)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 3.26 lbs

REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3772	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BACK LEG	NTS
DATE	08.03.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

no bend die
radius die
\$\$\$



D3772-1 BACK LEG

PROTOTYPE
PLEASE RETURN ALL ISSUED
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08.04.23

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3772	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BACK LEG	1:1
DATE	08.03.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Receiving Report

Date: 8/6/7
Supplier: M26NA

Batch No: M/107952
Dart P/O: 6270

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐
Waybill Attached: Yes ☐ No ☒
Shipment Complete: Yes ☒ No ☐ N/A ☐
QC6 Inspection 2008/10/7 N/A ☐
Work Order N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin:
Date: 08/05/08
Received/Costing: RCP 7826
Initial: CL

Location

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

Heat # 168/12-3

RECEIVED MAY 13 2008

Sub-Total
G.S.T.

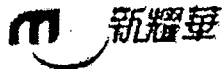
1090.00
54.50

TOTAL →

1144.50

FRAIS D'ADMINISTRATION DE 1½% PAR MOIS (18% PAR ANNÉE) SUR COMPTE PASSÉ DÙ.
LE PRÉSENT CONTRAT SERA RÉGI PAR LES LOIS DE LA PROVINCE DE QUÉBEC ET COMME
AYANT PRIS NAISSANCE DANS LE DISTRICT JUDICIAIRE DE MONTRÉAL.
ADMINISTRATION CHARGES OF 1½% PER MONTH (18% PER YEAR) ON OVERDUE ACCOUNTS.
THE PRESENT AGREEMENT SHOULD BE GOVERNED BY THE QUEBEC LEGISLATION AND SHOULD
BE CONSIDERED AS HAVING ORIGINATED IN THE JUDICIAL DISTRICT OF MONTREAL.

HUZHOU XINYAOHUA STAINLESS STEEL PIPES & TUBES CO., LTD.
CHANGCHAO IND.ZONE, HEFU TOWN, HUZHOU CITY, ZHEJIANG PROVINCE, CHINA



MILL TEST CERTIFICATE to EN 10204/3.1

Customer:
Specification: A7SA 213-05a, A-269-02
Steel Grade: TP316/316L
Goods: Seamless Stainless Steel Tubes

Cert No.: XYH-07-08-43
Delivery Condition: Annealed & Pickled & OD Polish
Contract No.: 07MGS/LL20

Heat No.	Chemical Composition(%)									
	C	Mn	P	S	Si	Ni	Cr	Mo	N	Ti
0705-120	0.017	0.80	0.040	0.001	0.49	10.11	16.23	2.05		
Lot No.	Size				Quantity					
8A-117	O.D. 1 1/4" * A.W.0.095"				500 FT 276 KGS					
8A-118	O.D. 1 1/4" * A.W.0.12"				1000 FT 684 KGS					
8A-120	O.D. 1 1/2" * A.W.0.083"				500 FT 290 KGS					
Lot No.	Mechanical Properties (Under Room Temperature)						Size & Surface			
	Yield Strength Mpa	Tensile Strength Mpa	Elongation (%)	Hardness Test HRB	Flaring Test	Flattening Test	Size Check	Surface Quality		
8A-117	285/290	585/575	49/48	78/79	Acceptable	Acceptable	Acceptable	Acceptable		
8A-118	275/280	580/590	46/47	76/77	Acceptable	Acceptable	Acceptable	Acceptable		
8A-120	290/285	570/585	48/49	78/76	Acceptable	Acceptable	Acceptable	Acceptable		
Lot No.	Nondestructive Examination			Intergranular		Grain Size				
	Eddy Current Test Acc to ASTM E426	Ultrasonic Test	Hydrostatic Test	Corrosion Acc to ASTM A262 E		Acc to ASTM E112				
8A-117	Acceptable									
8A-118	Acceptable									
8A-120	Acceptable									
Additional Remarks: The pipes are acc.to ASTM A1016 / A1016M-02a and conform to NACE MR0175										
Annealing Temperature 1100°C										
We hereby certify that the material described above has been tested and sampled and complies with the terms of the Contract & the specification.										
				Quality Technology Director						

湖州新耀华不锈钢管有限公司
HUZHOU XINYAOHUA STAINLESS STEEL PIPES & TUBES CO., LTD.

CG 829